

Date: Thursday, 4/12/2007 8:21:30 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB ASSEMBLY
Job Number : 31651	
Estimate Number : 10194	
P.O. Number : <i>N/A</i>	Part Number : D2174041
This Issue : 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2174 REV E
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 30808	Material : <i>N/A</i>
Written By : _____	Due Date : 4/30/2007 Qty: 40 Um: Each
Checked & Approved By : <i>07.04.12</i>	33
Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21741	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	<i>B31689 x 33mx -</i>

2.0	D21751	Angle LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	<i>B30871 x 4mx, B31690 x 29mx -</i>

3.0	D21752	Angle RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	<i>B31441 x 18mx, B31691 x 15mx -</i>

4.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 19.0000 Each(s)/Unit Total : 760.0000 Each(s)
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	<i>m103691 -</i>

MF 07-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:30 AM
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Drawing Name: WEB ASSEMBLY

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Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1:



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per Dwg D2174-041
2- Identify as D2174-041

MF 07-05-28

(32)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/30

(33)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103141

BR/FEL. 07-05-31

(33)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF 07-06-05

9.0 AN526C832R14 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Screw
Batch: M9216

10.0 AN960JD8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Washer
Batch: M103585¹²⁵

(35)

M104093

11.0 MS21042L08 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)
Nut
Batch: M104118

2/2/1 SA

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install nuts & bolts loosely as per Dwg D2274

MF 07-06-05

(33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 31651

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/05 (33)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (33)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(33)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

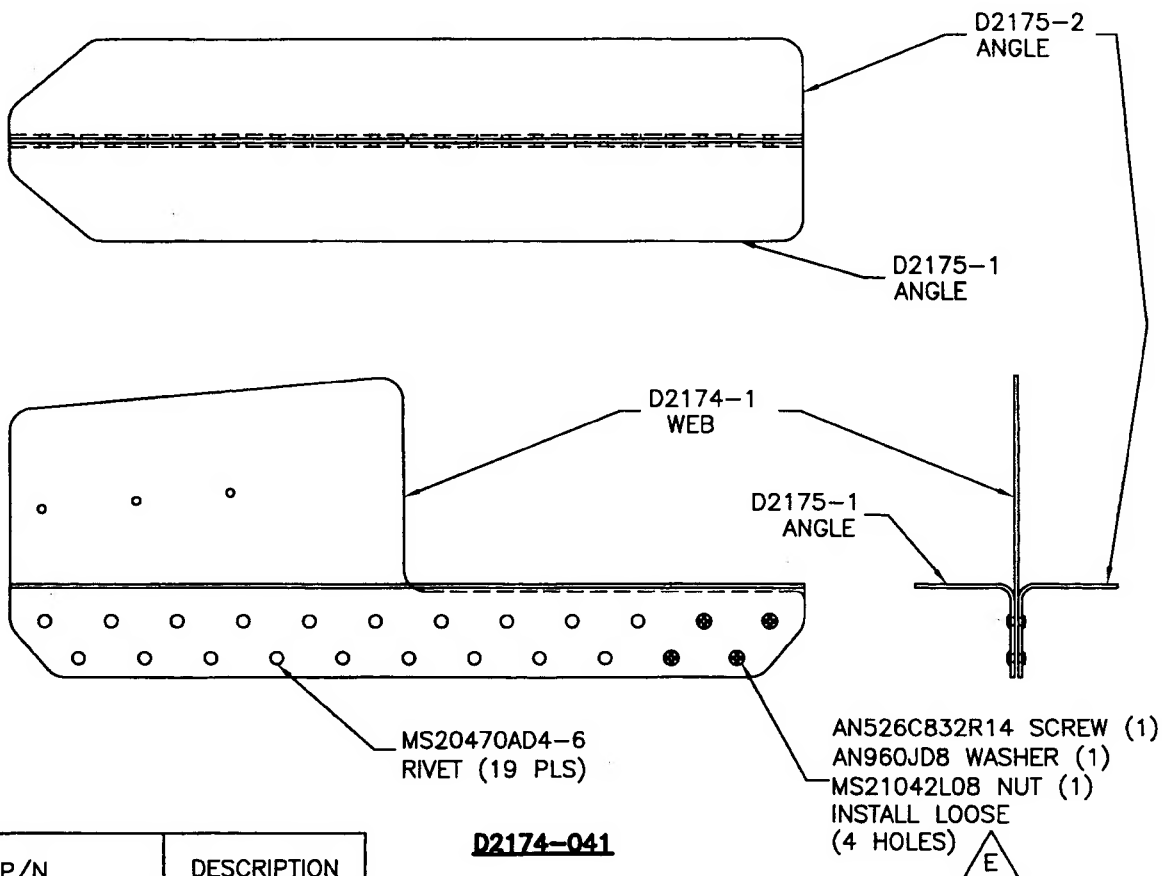
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED CH	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

SHOP COPY
RETURN TO
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WORK ORDER
NO. 31651

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13-11

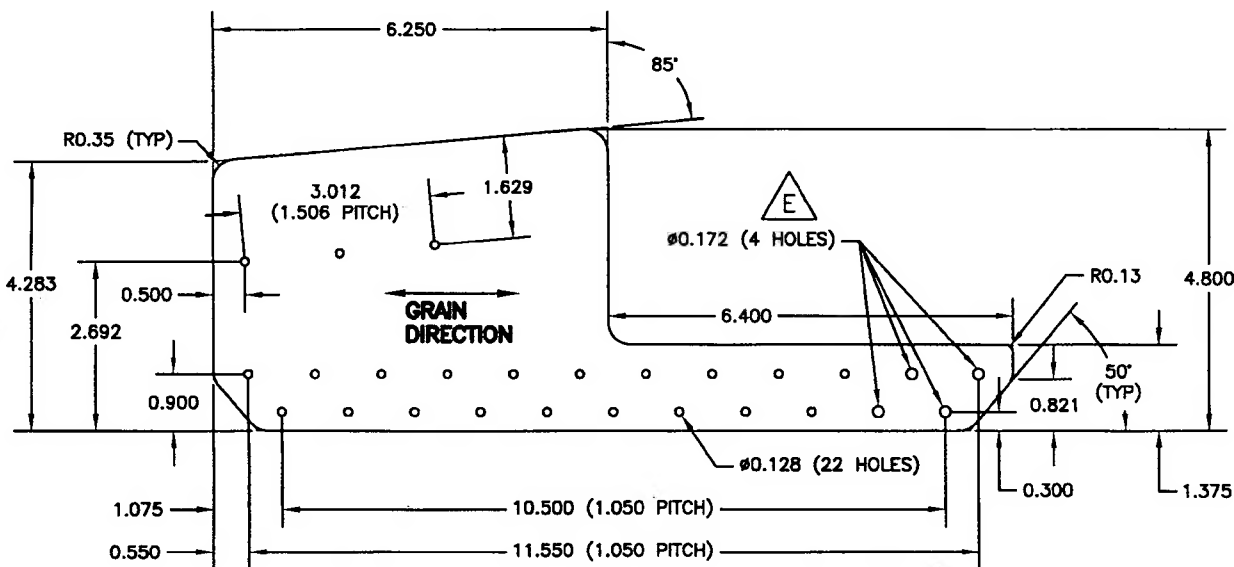
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DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	PH	APPROVED	[Signature]	DRAWING NO. D2174	SHEET 2 OF 2
DATE	06.09.25	TITLE	WEB	SCALE	1:3

RELEASED
06.10.23



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

WORK ORDER
NO. 31651
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ENGINEERING
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STOP COPY